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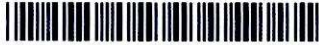
D3211-1
Job Sheet 213321



Part No: D3211-1

Job Qty: 6 pcs

Part Name: Bracket For Interior Window For -015 & -025



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/22/20

Job Tracking No:

Due Date: 10/26/20

Created By: Marie Lajeunesse

Type: Stock *SOUD*

Description: SIOP

Note: DWG REV B IPP Rev:A New Issue 05-11-17 JLM IPP Rev:B Now on Waterjet 06-10-24 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		10/24/20	0.17	1.29	Waterjet - Flow		<i>on 20/10/05</i>
120	QC 8	6 pcs		10/24/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		

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				QC 8 - 82	
140 Small Fab - Brake NC - B4B	6 pcs	10/24/20	0.25 0.80	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	OCT 08 2020
150 QC 5	6 pcs	10/24/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
160 Handfinish - 1-1 Chemical-B4B	6 pcs	10/24/20	0.00 0.32	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
170 Powdercoat - 4 Black Sand -	6	10/26/20	0.00 0.19	Powdercoat - 1 - B4B	

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B4B <i>M254469.</i> <i>START: 10:25.</i> <i>OUT: 320°</i> <i>FINISH: 10:55.</i> 180 QC 3	6 pcs	10/26/20	0.00 0.00	Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	<i>20-10-16</i>
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
190 Packaging 3-1 - Stock - B4B 6 pcs	6 pcs	10/26/20	0.00 0.00	QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
				QC 3 - 47	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	

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				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
200 QC 21 - SA	6 pcs	10/26/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	OCT 19 2020
				QC 21 - SA - 9	70
				QC 21 - SA - 77	9-89
				QC 21 - SA - 28	

Part Op **100** - 1-Cut as per Dwg D3211
 Descriptions: **120** - (QC8- Inspect parts - second check)
140 - (Form as per dwg) Bend D3211-1 Stack as per Dwg D3211
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Chemical Conversion Coat per QSI005 4.1)
170 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____
180 - (QC3- Inspect Part Finish)
190 - (Identify as per dwg & Stock Location: _____)
200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	8.4300 sf (1.405 ea)	100-Waterjet - Flow - 1	S265836

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	8	130	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.250inches ± 0.030	0.280 0.220		
2	Bracket	1.910inches ± 0.030	1.940 1.880		
3	Bracket	0.128inches + 0.005 - 0.000	0.133 0.128		
4	Bracket	0.141inches + 0.005 - 0.000	0.146 0.141		
5	Bracket	17.710inches ± 0.030	17.740 17.680		
6	Bracket	1.910inches ± 0.030	1.940 1.880		
7	Bracket	1.560inches ± 0.030	1.590 1.530		
8	Bracket	11.320inches ± 0.030	11.350 11.290		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____ _____ _____					

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Container No: S304802



Part: D3211-1

Job No: 213321

Serial No/Batch: S304802

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/05/00



Checksheet 11796 - In Process

Part D3211-1- Bracket For Interior Window For -015 & -025	Operation Waterjet - Flow - 1	Inspection Step QC2	Workcenter Waterjet - Flow	SPC Checksheet Container Text S304802	Job No 213321
Date/Time 10/5/20 8:05 AM	Inspector Conway, Dereck	Special Comments			

Open Duration						
00:02 (hh:mm)						
	No	Specification	Target	Limits	Measurements	Special Comments
	1	Bracket	0.250 inches Radius	0.280 0.220	<u>0.250</u>	
	2	Bracket	1.910 inches	1.940 1.880	<u>1.914</u>	
	3	Bracket	0.128 inches	0.133 0.128	<u>0.128</u>	
	4	Bracket	0.141 inches	0.146 0.141	<u>0.141</u>	
	5	Bracket	17.710 inches	17.740 17.680	<u>17.710</u>	
	6	Bracket	1.910 inches	1.940 1.880	<u>1.918</u>	
	7	Bracket	1.560 inches	1.590 1.530	<u>1.566</u>	
	8	Bracket	11.320 inches	11.350 11.290	<u>11.325</u>	

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